

Work Order ID 81671

March-16-12 1:57:15 PM

Ship March 22

\*81671\*

Page 1

Item ID: D407-802-012

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Crew Door Opener Installation, RH

Start Date: 16/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/12

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-012 CHG001

Scrub 12/27

MLJ 12-3-20

105

Pick Kit

0.00

\*105\*

Packaging

Memo

0.00

Packaging

12/3/12

110

QC4- 100% Inspect kits for completeness

0.00

\*110\*

QC

Memo

0.00

Quality Control

Scrub 12/27

(7)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81671****\*81671\***

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Item ID: D407-802-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crew Door Opener Installation, RH

Start Date: 16/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-012								
	Location: <u>11</u>								
	PPP rev: <u>h</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

12/4/2012

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 81671

\*81671\*

Parent Item: D407-802-012

\*D407-802-012\*

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.02 per revA DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15 *D3552-15* Door Prop		Manufactured	No			105	Each	18.0000	1	1			
										**			

Location	Loc Qty	Loc Code
ST272	18	
65119	1	
79271	11	
80346	6	

D3622-5 *D3622-5* Ball Stud		Manufactured	No			105	Each	24.0000	2	2			
										**			

Location	Loc Qty	Loc Code
ST058	24	
76963	4	
80406	20	

D4106-2 *D4106-2* Sill Doulber, RH		Manufactured	No			105	Each	6.0000	1	1			
										**			

Location	Loc Qty	Loc Code
ST127	6	
77120	6	

D4106-4 *D4106-4* Crew Door Doulber, RH		Manufactured	No			105	Each	10.0000	1	1			
										**			

Location	Loc Qty	Loc Code
ST127	10	
70064	1	
79341	9	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D407-802-012

\*D407-802-012\*

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4106-5 Manufactured No

105 Each 2.0000 1

\*D4106-5\*

Spacer, Sill Doublor

\*\*

## Location

## Loc Qty

## Loc Code

ST127

2

64341

2

D4106-7 Manufactured No

105 Each 9.0000 1

\*D4106-7\*

Template

\*\*

## Location

## Loc Qty

## Loc Code

ST127

9

76460

3

79172

6

CR3523-4-02 Purchased No

105 Each 657.0000 26

\*CR3523-4-02\*

RIVET

\*\*

## Location

## Loc Qty

## Loc Code

ST332

657

116391

100

116893

3

116915

1

117978

38

120308

100

120422

15

120873

400

CR3523-4-4 Purchased No

105 Each 68.0000 4

\*CR3523-4-4\*

Rivet

\*\*

## Location

## Loc Qty

## Loc Code

ST332

68

119717

68

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D407-802-012

\*D407-802-012\*

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-5

Purchased

No

105

Each

50.0000

3

3

\*CR3523-4-5\*

Rivet

\*\*

3

SP

Location

Loc Qty

Loc Code

ST332

50

117423

50

3

CR3523-4-6

Purchased

No

105

Each

128.0000

8

8

\*CR3523-4-6\*

Rivet

\*\*

8

SP

Location

Loc Qty

Loc Code

ST314

28

116606

28

8

ST332

100

120422

100

CR3523-4-07

Purchased

No

105

Each

47.0000

7

7

\*CR3523-4-07\*

RIVET

\*\*

SP

Location

Loc Qty

Loc Code

ST332

47

116606

44

2

17768

3

MS20426AD4-5

Purchased

No

105

Each

5,032.000

4

4

\*MS20426AD4-5\*

Rivet

\*\*

4

SP

Location

Loc Qty

Loc Code

ST317

5032

6874

5032

4

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D407-802-012

**\*D407-802-012\***

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

38.0000

2

**\*MS21073L5\***

nut plate

\*\*

Location

Loc Qty

Loc Code

ST302

28

117395

28

ST303

10

120986

10

NAS1149C0532R

Purchased

No

105

Each

485.0000

6

**\*NAS1149C0532R\***

WASHER

\*\*

Location

Loc Qty

Loc Code

ST297

485

116373

1

116513

53

118384

31

119736

400

NAS1149C0563R

Purchased

No

105

Each

422.0000

6

**\*NAS1149C0563R\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

222

116391

22

117460

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 5.0 PARTS LIST

## 5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
		D407-802-011	CREW DOOR OPENER KIT, LH
		D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4106-1	SILL DOUBLER, LH
	1	D4106-2	SILL DOUBLER, RH
1		D4106-3	CREW DOOR DOUBLER, LH
	1	D4106-4	CREW DOOR DOUBLER, RH
1	1	D4106-5	SPACER, SILL DOUBLER
1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER